










Work Order ID 64090

Wednesday, November 24, 2010 8:51:01 AM

Page 1

Item ID:	D2665-2	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Saddle, RH Fwd Aft Out 206					
Start Date:	11/24/2010	Start Qty:	4.00	Cust Item ID:		
Required Date:	12/16/2010	Req'd Qty:	4.00 2.0	Customer:		
Reference:						

Approvals:	Process Plan:		Date:	10-11-24	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2665	Rev D								
100	HAAS CNC VERTICAL MACHINING #1	0.00							
	HAAS 1								
HAAS CNC vertical machine #1	Memo 1- Program batch number <input type="checkbox"/> 2- Machine Step # 1 of Folio and visually inspect as per attached Dimension Sheet <input type="checkbox"/> 3- Machine Step # 2 of Folio and visually inspect as per attached Dimension Sheet <input type="checkbox"/> 4- Machine Step # 3 of Folio and visually inspect as per attached	0.00				2	0		
				B.A. 11/01/04					
110	CONVENTIONAL MILLING MACHINE	0.00							
	Mill Conv								
Conventional Milling Machine	Memo Machine Keyway and inspect per attached dimension sheet	0.00				2	0		
				B.A. 11/01/10					
120	QC2- Inspect parts off machine FAI/FAIB	0.00							
	QC								
Quality Control	Memo	0.00				2	0		
				B.A. 11/01/04					

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 64090



Page 2

Wednesday, November 24, 2010 8:51:01 AM

Item ID:	D2665-2	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Saddle, RH Fwd Aft Out 206					
Start Date:	11/24/2010	Start Qty:	4.00		Cust Item ID:	
Required Date:	12/16/2010	Req'd Qty:	4.00		Customer:	
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00		11/20/11		(2)			
140 HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00				2	0	11/20/12	
150 Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum 1115951 Memo START TIME: 9:00 350° FINISH TIME: 9:30	0.00 0.00				2	BR	11-01-13	

OVEN TEMPERATURE:

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 64090

Wednesday, November 24, 2010 8:51:01 AM

Page 3

Item ID: D2665-2

Accept

Setup Start

Revision ID:

Stop

Item Name: Saddle, RH Fwd Aft Out 206

Start Date: 11/24/2010 Start Qty: 4.00

Cust Item ID:

Required Date: 12/16/2010 Req'd Qty: 4.00

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

2 of 2 11/01/13

170

Identify as per dwg & Stock Location: 436

0.00



Packaging

Memo

0.00

Packaging

11/01/14 (2)

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/01/14

11.01.14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Wednesday, November 24, 2010 8:51:05 AM

Page 1

Work Order ID: 64090



Parent Item: D2665-2



Parent Item Name: Saddle, RH Fwd Aft Out 206


Start Date: 11/24/2010

Required Date: 12/16/2010

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP: C 00.11.01 Removed P/O for Powder Coat - in house process
EC
IPP Rev:D As per Rev D 07-03-19 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6101-003  Saddle Billet, 7075		Manufactured	No			100	Each	0.0000	1	4			

B63560

B.A 11/01/04

Qty: 4.0

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order: <u>44020</u>
Description: 206 Saddle, Outboard, Right side	Part Number: D2665-2
Inspection Dwg: D2665 Rev. D	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2665 Rev.D C and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	#	# 1	# 2	#	By	Date
A	0.100	0.140			0.105	0.110		Mic	GA-03
B	0.100	0.140			0.119	0.122		Mic	GA-03 118-120
C	1.125	1.145			1.135	1.1348		Dial	HAAS 3
D	0.615	0.685			0.670	0.670		Vern	GA-01
E	0.240	0.260			0.253	0.253		"	"
F	1.313	1.343			1.328	1.328		"	"
G	0.210	0.230			0.224	0.224		"	"
H	0.100	0.180			0.125	0.125		"	"
I	2.470	2.510			2.492	2.492		"	"
J	1.565	1.585			1.5742	1.5741		Dial	HAAS 3
K	0.235	0.240			0.237	0.237		Vern	GA-01
L	0.100	0.120			0.110	0.110		D-6	GA-08
M	0.990	1.010			1.000	1.000		Vern	GA-01
N	0.510	0.515			0.515	0.510		"	"
O	5.990	6.010			6.000	6.000		"	"
P	1.245	1.255			1.250	1.250		"	"
Q	2.495	2.505			2.500	2.500		"	"
R	0.313	0.318			0.314	0.314		"	"
S	0.315	0.322			0.317	0.317		"	"
T	2.495	2.505			2.500	2.500		"	"
U	1.357	1.367			1.362	1.362		"	"
V	0.787	0.807			0.796	0.798		"	"
W	0.540	0.560			0.551	0.556		"	"
X	1.674	1.684			1.679	1.679		"	"
Y	0.257	0.262			0.259	0.259		"	"
Z	0.912	0.932			0.925	0.924		"	"
AA	0.490	0.510			0.501	0.508		"	"
AB	0.178	0.198			0.188	0.188		R-6	ref.
AC									
AD									
AE									
AF									
Accept/Reject									

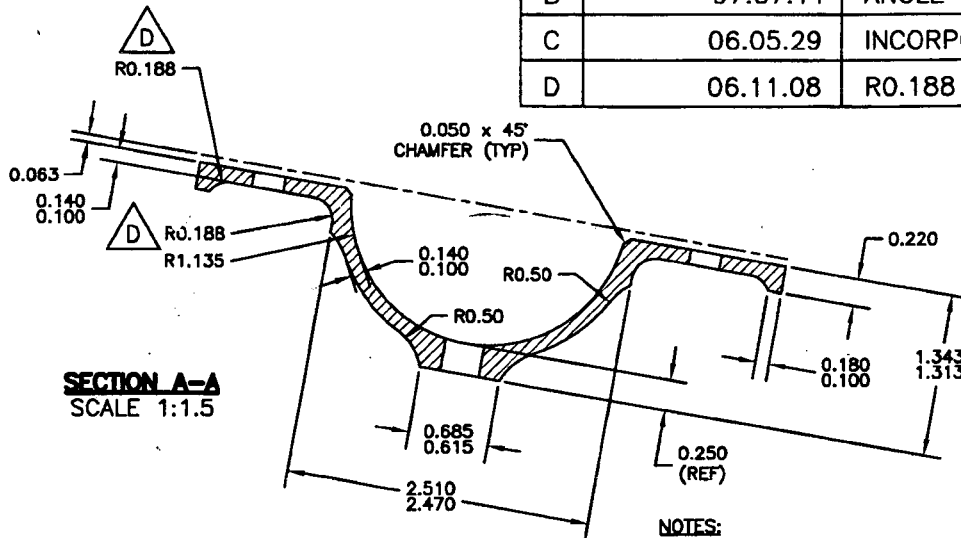
Measured by: <u>G.A.</u>
Date: <u>11/01/04</u>

Audited by: <u>[Signature]</u>
Date: <u>11/01/11</u>

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.10	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686	KJ/RF	
E	06.07.05	Revised per drawing revision C	KJ/JLM	
F	07.03.21	Revised per drawing revision D	KJ/JLM	<u>[Signature]</u>

DART

DESIGN #	DRAWN BY CB	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED PH	APPROVED #	DRAWING NO. D2665	REV. D SHEET 1 OF 1
DATE 06.11.08		TITLE SADDLE FWD OUTSIDE HIGH	SCALE 1:3
A	97.03.25	NEW ISSUE	
B	97.07.11	ANGLE AND NOTES ADDED	
C	06.05.29	INCORPORATE DEO 9122, 9102, 9095	
D	06.11.08	R0.188 WAS R0.30; Ø0.316 WAS Ø0.313	



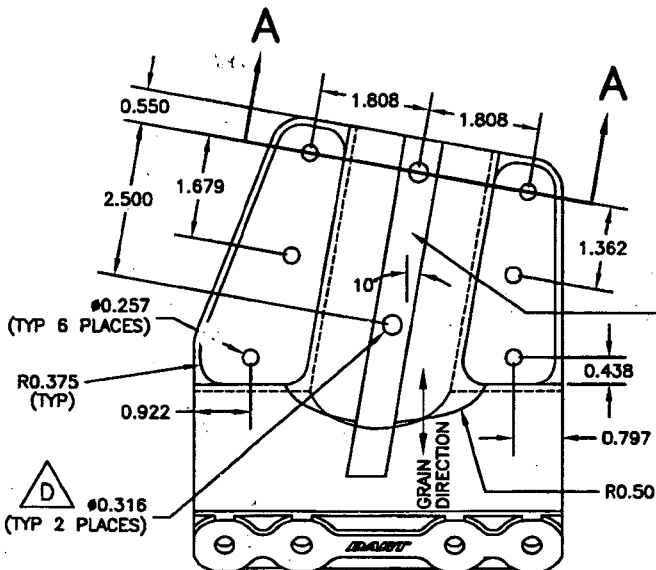
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07.02.12

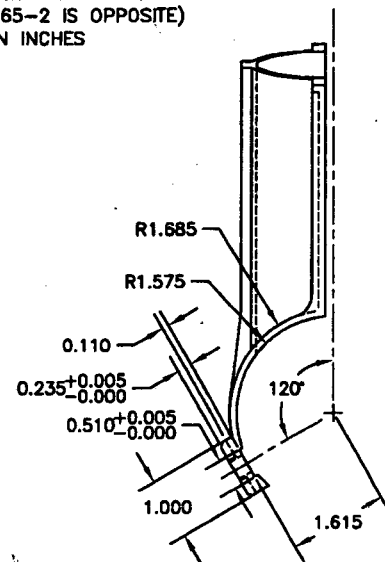
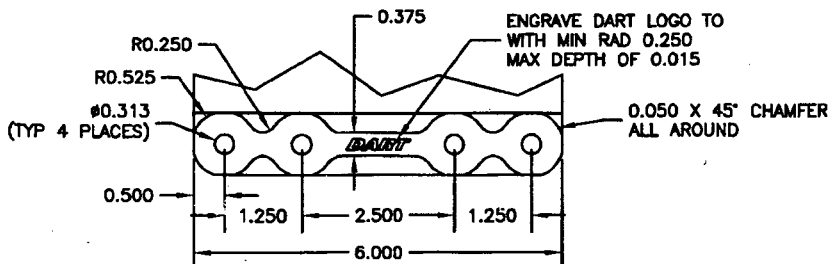
SHOW
REVISION
ENGINEERING
UNCONTROLLED
SUBJECT TO APPROVAL
WITHOUT NOTICE
WORK ORDER

NOTES:

- 1) MATERIAL: ALUMINUM 7075-T7351 (QQ-A-250/12) (MAKE FROM D6101-003 SADDLE BILLET, 7075)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER COAT GLOSS WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 5) D2665-1 SHOWN (D2665-2 IS OPPOSITE)
- 6) ALL DIMENSIONS ARE IN INCHES



ENGRAVE PART
NUMBER AND
BATCH NUMBER
TO MAX DEPTH
OF 0.010 WITH
MIN RADIUS
OF 0.010

**D2665-1 SADDLE FWD OUTSIDE HIGH****Copyright © 1997 by DART AEROSPACE USA, INC.**

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